



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-351
Job Sheet 175583



Part No: D206-642-351

Job Qty: 1 ea

Part Name: Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D4361-041 REV A, IIN-D206-642 REV Q SHEETS 29-30 IPP REV:A NEW ISSUE 12-07-09 JLM
VERIFIED BY:EC

Ship Via:

Bill of Materials

MUST Ship April 20th

DART
AEROSPACE
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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
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Container No: S059487
Part: D206-642-351
Job No: 175583
Serial No/Batch: S059487
Revision:
Inspector:

Date: 04/10/18

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Skid tubes-1		JLB
110	Skid tubes	1 pcs		4/17/18	0.00	3.26	Skid tubes-2		BE J.4
115	QC	1 pcs		4/17/18	0.00	0.00	QC5		KE
120	HandFinish	1 pcs		4/17/18	0.00	0.83	HandFinish1		SA 18-04-12
125	QC	1 pcs		4/17/18	0.00	0.00	QC7-1		BE
130	Skid tubes	1 pcs		4/17/18	0.00	3.26	Skid tubes-2		BE Mch
140	QC	1 pcs		4/17/18	0.00	0.00	QC5		BE
150	Skid tubes	1 pcs		4/17/18	0.00	3.26	Skid tubes-2		BE Mch
170	QC	1 pcs		4/17/18	0.00	0.00	QC10		35 DAS
180	QC	1 pcs		4/17/18	0.00	0.00	QC5		3-88 35
190	HandFinish	1 pcs		4/17/18	0.00	0.83	HandFinish2		BE 18-04-17
200	Powdercoat	1 pcs		4/17/18	0.00	0.23	Powdercoat1		BE 18-04-17
210	QC	1 pcs		4/17/18	0.00	0.00	QC3		BE 18-04-18
220	HandFinish	1 pcs		4/18/18	0.00	0.83	HandFinish4		BE 18-04-23
230	QC	1 pcs		4/18/18	0.00	0.00	QC3		35 DAS
240	QC	1 pcs		4/18/18	0.00	0.00	QC5		3-88 35
245	DC	1 pcs		4/18/18	0.00	0.00	DC		3-88
250	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		J.R.B. SMP
260	QC21-FG	1 Ea		4/18/18	0.00	0.00	QC21		35 DAS

Part Op 110 - 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D4361 3-Weld Fwd Cap as per Dwg D4361 4-Grind D2647 to fit as required. 5-Cut aft end to length as per Dwg D4361 6-Drill pilot holes using drill Jig DT8168A and DT8168B and DT8025. Most Fwd wearplate hole to be laid out manually. 8-Open Aft Cap Hole using # Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-041 Drilling Detail 10-Remove inner indexing ridge on aft end of skid tubes as per Dwg D4361 11-Deburr and Blow out all chips from inside the tube 130 - 1-Open holes to finished size as per Dwg D4361, D4361-041 Drilling Detail 2-Countersink crossbolt spacer holes as per Dwg D4361 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-5 web in place as per QSI 015, Ensure holes line up. Allow 12 Hrs. cure time

150 - 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 2-Grind welds flush as per Dwg D4361. 3-Counterbore 5/16" x 0.750" deep as per Dwg D4361. Deburr 4- Install nut plate as per Dwg

190 - AND ALODINE ONLY AS PER QSI005

200 - Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

220 - 1-Install wearplates as per Dwg D4361. 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D4361. Clean excess adhesive 6-Wing Walk as per Dwg D4361-041 and QSI 005 4.4

245 - Photocopy bluefile and create labels per PPP D206-642-351 CHG001

250 - Identify and pack for shipping as per PPP D206-642-351

M 138760 START: 3:25. O.V.T: 3:30 FINISH: 3:55.

wing walk 138761.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 Ea (1 ea)	90-Start up Operation	5038805
D2647	Cap	1 Ea (1 ea)	90-Start up Operation	8164474
D2654-5	Web	1 Ea (1 ea)	130-Skidtubes	5011680
D2649	Cross Bolt Spacer	23 Ea (23 ea)	150-Skidtubes	F153819 x 7 13050570-110
AN3-36A	Bolt	9 Ea (9 ea)	220-HandFinish	8x FM1374167/502 2616-1
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-HandFinish	FM137622
CR3212-4-3	Cherry Rivet	2 Ea (2 ea)	220-HandFinish	FM137886-0
D2646	Aft Cap	1 Ea (1 ea)	220-HandFinish	F164005
D2651-1	Plug	4 Ea (4 ea)	220-HandFinish	F163288x2 F165327 x2
D2651-3	O-Ring	4 Ea (4 ea)	220-HandFinish	5044502
D2680-041	Nut Plate	1 Ea (1 ea)	220-HandFinish	F158428
D3873-1	Bushing	18 Ea (18 ea)	220-HandFinish	5056873
D4364-041	Run-on Landing Wearplate Fwd	1 Ea (1 ea)	220-HandFinish	5062574
D4364-043	Run-on Landing Wearplate Aft	1 Ea (1 ea)	220-HandFinish	7140344-115
MS21042-3	Nut	9 Ea (9 ea)	220-HandFinish	5027548
MS27039-1-08	Screw	2 Ea (2 ea)	220-HandFinish	FM138209-1
MS27039-4-06	Screw	1 Ea (1 ea)	220-HandFinish	FM137951-1
NAS1149C0332R	Washer	9 Ea (9 ea)	220-HandFinish	5044236
NAS1149D0332J	Washer	2 Ea (2 ea)	220-HandFinish	5020606
NAS1149D0463J	Washer	1 Ea (1 ea)	220-HandFinish	5045845

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2620	1	3	0
	D2647	1	23	0
130-Skidtubes	D2654-5	1	9	0
150-Skidtubes	D2649	23	355	0
220-HandFinish	AN3-36A	9	60	0
	CCR264SS3-3	2	168	0
	CR3212-4-3	2	205	0
	D2646	1	100	0
	D2651-1	4	312	0
	D2651-3	4	689	0
	D2680-041	1	53	0
	D3873-1	18	138	0
	D4364-041	1	3	0
	D4364-043	1	9	0
	MS21042-3	9	258	0
	MS27039-1-08	2	608	0
	MS27039-4-06	1	87	0
	NAS1149C0332R	9	7,042	0
	NAS1149D0332J	2	3,192	0
	NAS1149D0463J	1	5,730	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 2:33 PM Dart.Gagnon.Michelle

002717.

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-160	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

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WORK ORDER
NO. 175583

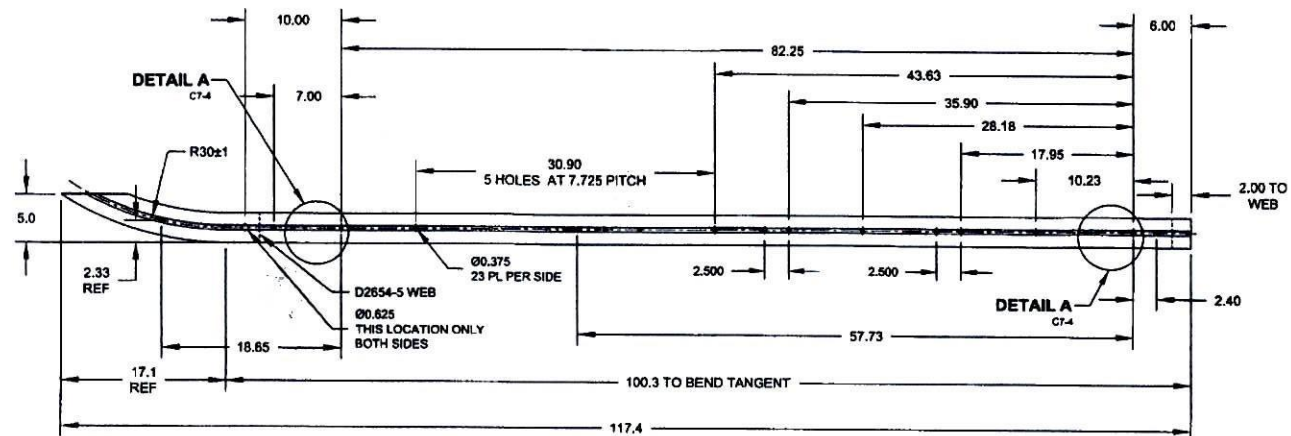
APR 06 2018

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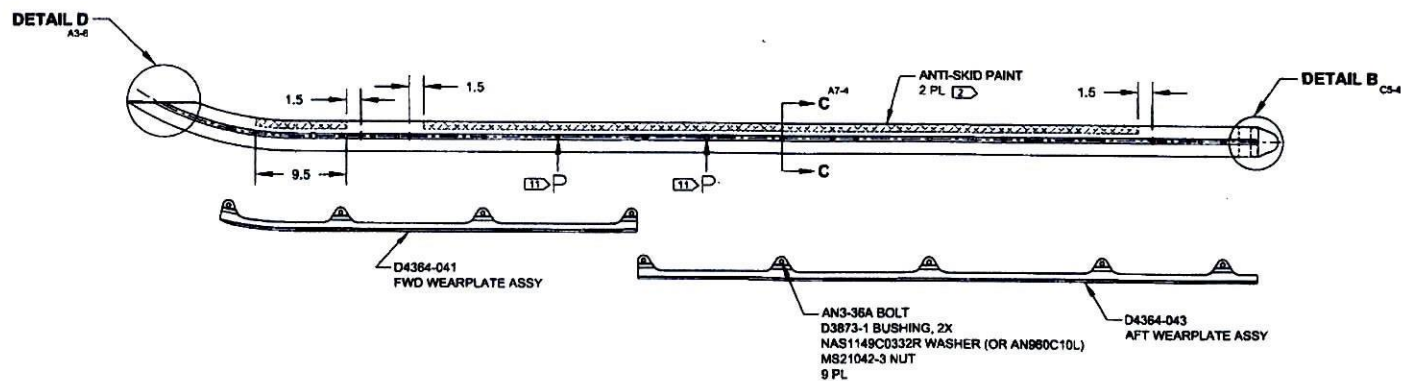
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE.
A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

RELEASED
2011-09-12

A	NEW ISSUE	SC	11.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	BE	D4361	SHEET 1 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	206L/407 SKIDTUBE ASSEMBLIES	NTS
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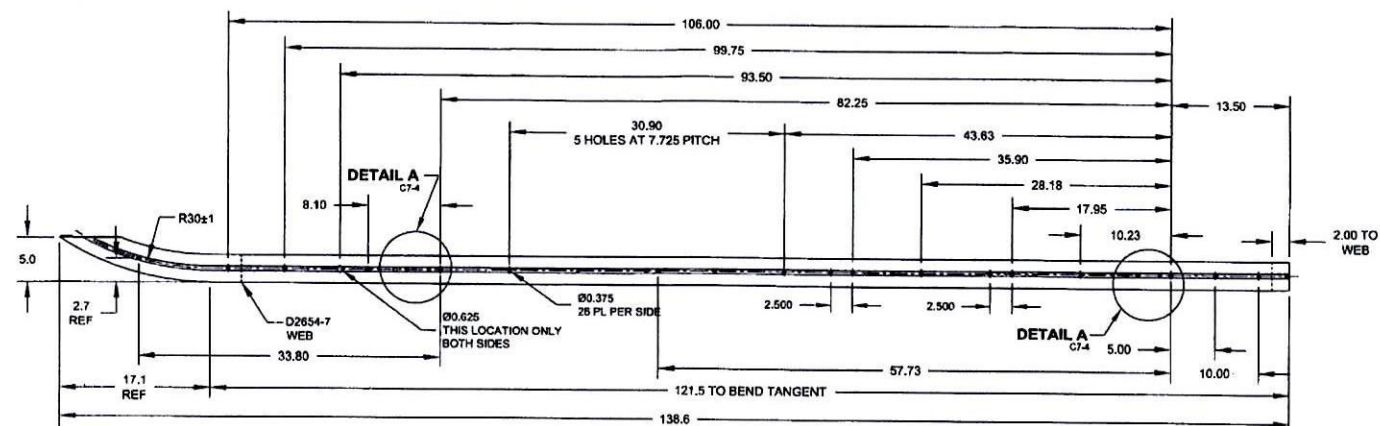
D4361-041 BENDING/DRILLING DETAIL



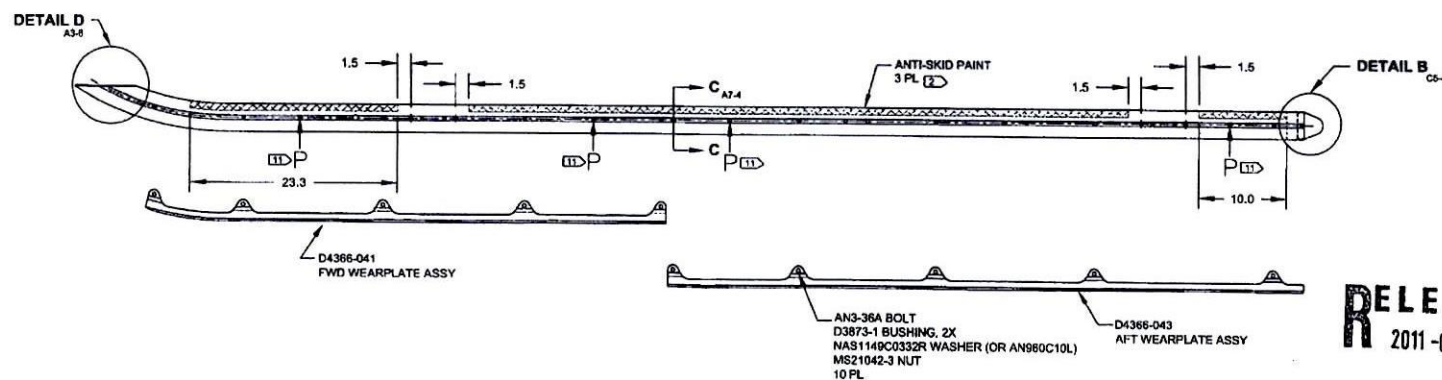
D4361-041 ASSEMBLY/FINISHING DETAIL

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MFG. APPR.	97	D4361	SHEET 2 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	206L/407 SKIDTUBE ASSEMBLIES	NTS
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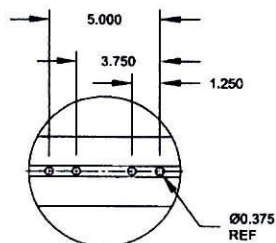
D4361-043 BENDING/DRILL DETAIL



D4361-043 ASSEMBLY/FINISHING DETAIL

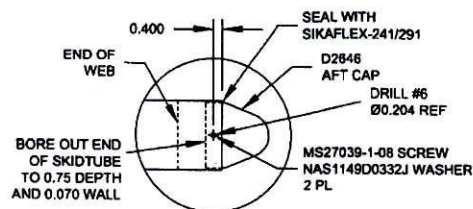
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MFG. APPR.	FE	D4361	SHEET 3 OF 4
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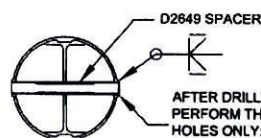
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

B2-2
B1-3

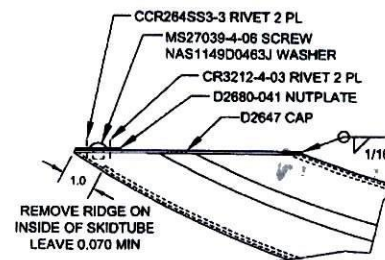


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

**SECTION C-C
FOR Ø0.375 HOLES
ONLY**

B4-2
B5-3

ORIENTATION OF
D2680-041



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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